



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB23008673-1
Job Sheet 178377



Part No: RB23008673-1

Job Qty: 2 ea

Part Name: Spline



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/30/18

Job Tracking No:

Due Date: 7/23/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB23008673 Rev. 0 IPP Rev. A 18.05.25 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs		7/23/18	0.00	0.00	Purchasing		JUL 20 2018
110	Packaging	2 pcs		7/23/18	0.00	0.00	Packaging2		JUL 20 2018
120	QC	2 pcs		7/23/18	0.00	0.00	QC6		PD 13-07-23
122	Outsource	2 pcs		7/23/18	0.00	0.00	Outsource12		CT 18-7-23
124	Packaging	2 pcs		7/23/18	0.00	0.00	Packaging2		13-07-23
126	QC	2 pcs		7/23/18	0.00	0.00	QC6		38
130	Packaging	2 pcs		7/23/18	0.00	0.00	Packaging3		9-88 MLC
140	QC21-FG	2 Ea		7/23/18	0.00	0.00	QC21		JUL 26 2018

Part Op 100 - Issue PO to P.J. MACHINAGE P/O: 040204 MANUFACTURE RB23008673-1 AS PER DWG -Certificate of Descriptions: conformity is required

122 - -Issue P/O to GROUPE ALTECH; PO 040560 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required

14 June 2018 x 2 R h

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB23008673-1P	Handle	2 Ea (1 ea)	100-Purchasing	5094647

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB23008673-1P	2	0	0

Part Specifications

Specifications could not be found.

Plex 7/20/18 10:10 AM dart.Lussier.Patrick



Container No: S094651



Part: RB23008673-1

Job No: 178377

Serial No/Batch: S094651

Revision: 0

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/20/18

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28.9



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO040204

Supplier: PJM001-VC
P.J. Machinage
1381 Rte Cite-Des-Jeunes
St-Lazare
QC
J7T 2B8
Phone: 450-455-0705

PO No: PO040204
PO Date: 6/14/18
Due Date: 7/23/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		RB6889891P			HOLDER, COMPRESSOR ROTOR	Firmed	-	7/23/18	2 pcs	0 pcs	2 pcs	\$443.50/pcs	\$887.00
Line Item Note		W/O 178370											
2		RB6891195-1P			Locator	Firmed	-	7/23/18	6 Ea	0 Ea	6 Ea	\$182.45/Ea	\$1,094.70
Line Item Note		W/O 178232											
3		RB6891195-2P			Spline	Firmed	-	7/23/18	6 Ea	0 Ea	6 Ea	\$197.95/Ea	\$1,187.70
Line Item Note		W/O 178235											
4		RB23008673-1P			Handle	Firmed	-	7/23/18	2 Ea	0 Ea	2 Ea	\$406.05/Ea	\$812.10
Line Item Note		W/O 178377											
5		RB23008673-2P			Spline	Firmed	-	7/23/18	2 Ea	0 Ea	2 Ea	\$406.05/Ea	\$812.10
Line Item Note		W/O 178378											
6		RB23008673-3P			Spline	Firmed	-	7/23/18	2 Ea	0 Ea	2 Ea	\$406.05/Ea	\$812.10
Line Item Note		W/O 178379											
Grand Total:												\$5,605.70	

Order Notes

Plex 7/20/18 1:48 PM dart.Lussier.Patrick

Order Notes**Procurement Quality Clauses**

A005 RIGHT OF ENTRY

A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/20/18 1:48 PM dart.Lussier.Patrick

Invoice

20/07/2018

24033

P.J. Machinage (9052 9470 Qc Inc).
1381, Rte Cité-Des-Jeunes,
St-Lazare, Qc
J7T 2B8 **Tel. : 450 455-0705**

Sales Rep. : Peter Jones
Reference : PO: PO040204-S/O:6779
Terms : C.O.D.
Ship : Votre camion

Customer : 628**Ship To :**

Dart Aerospace Ltd. (C.O.D.)
Accounts payable
1270 Aberdeen St
Hawkesbury, Ontario
K6A 1K7

Same

Fax: 1 613 632-5246

Item No.	Description	Ord	Inv.	B/O Qty	Price	Total	Tx
001	RB6889891-1 Rev. 3 Holder Compressor Rotor Splined (J-6779-A/628)	2	2	0	443.50	887.00	AB
002	RB6891195-1 Rev. 1 Puller Compressor Rotor Splined Adapter (J-6779-B/628)	6	6	0	182.45	1 094.70	AB
003	RB6981195-2 Rev. 1 Puller Compressor Rotor Splined Adapter (J-6779-C/628)	6	6	0	197.95	1 187.70	AB
004	RB23008673-1P Adaptor Checking-compressor rotor (J-6779-D/628)	2	2	0	406.05	812.10	AB
005	RB23008673-2P Adaptor Checking-compressor rotor (J-6779-E/628)	2	2	0	406.05	812.10	AB
006	RB23008673-3P Adaptor Checking-compressor rotor (J-6779-F/628)	2	2	0	406.05	812.10	AB
007	Credit fact: 24006	-1	-1	0	2550.99	-2 550.99	AB

**NET 30 days, Service charge 2% per month (24% per year) on
overdue accounts.**

Subtotal : 3 054.71

A) Regist : 870637832

TPS : 152.74

B) Regist : 1021079932

TVQ : 304.71

Total : 3 512.16

PJ Machinage**Certificate of conformance****Sold to:**

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON, K6A 1K7

Supplier address:

PJ Machinage
1381 Route Cité-Des-Jeunes
St-Lazare, Qc, J7T 2B8

Purchase Order: P0040204

This is to certify that the below names items were inspected and/or tested to your drawings, specifications and purchase order. Objective evidence are shipped with the products and are on file to support the verifications and/or tests and can be made available on request, unless otherwise noted.

<u>Part Number</u>	<u>Quantity</u>	<u>Description</u>
RB6889891-1 Rev. 3	2	<u>Holder Compressor Rotor Splined</u>
RB6891195-1 REV. 1	6	<u>Puller Compressor Rotor Splined Adapter</u>
RB6891195-1 REV. 2	6	<u>Puller Compressor Rotor Splined Adapter</u>
RB23008673-1P Rev. 1	2	<u>Adaptor Checking-compressor rotor</u>
RB23008673-2P Rev. 1	2	<u>Adaptor Checking-compressor rotor</u>
RB23008673-3P Rev. 1	2	<u>Adaptor Checking-compressor rotor</u>

Peter Jones, July 20, 2016

6779-F



ACIER VANGUARD LTÉE

2205 de l'Aviation, DORVAL, QUÉBEC, Canada, H9P 2X6.

Tel: (514) 685-1515 fax: (514) 685-1516

CERTIFICATE OF COMPLIANCE / CERTIFICAT DE CONFORMITÉ

P.O./No.de commande 134964	Customer / Client P. J. MACHINING	Packing slip/feuille d'emballage L45213-01	DATE 19-Jun-18
MATERIAL I.D.#/No. MATERIEL 2016-2648	GRADE / NUANCE O-1	HEAT TREATMENT / TRAITEMENT THERMIQUE ANNEALED / RECUIT ADOUCI	HEAT / COULÉE SG1310-C20

SHAPE / FORME Round / Rond	SIZE / DIMENSION 1.000" in.	SPECIFICATIONS ASTM A681-08, A388/A388M-11
PAYS D'ORIGINE:	TAIWAN	

CHEMICAL COMPOSITION / ANALYSE CHIMIQUE

	Carbon (C)		Silicon (Si)		Manganese (Mn)		Phosphorus (P)	
MINI / MAXI	0.850	1.000	0.100	0.500	1.000	1.400		0.030
ACTUEL%	0.910		0.230		1.210		0.019	
	Sulfur (S)		Chromium (Cr)		Nickel (Ni)		Molybdenum (Mo)	
MINI / MAXI		0.030	0.400	0.700	---	---	---	---
ACTUEL%	0.001		0.480		0.130		0.000	
	Copper (Cu)		Vanadium (V)		Aluminium (Al)		Tungsten (W)	
MINI / MAXI	---	---	---	0.300	---	---	0.400	0.600
ACTUEL%	0.130		0.190		0.000		0.490	

MECHANICAL PROPERTIES / PROPRIÉTÉS MÉCANIQUE

Yield strength / Élasticité	Tensile / Résistance à la traction	Elongation/Allongement(%)	Reduction area/ sufarce %	surface hd/dureté
PSI	PSI			206 BHN

No weld repairs performed during the manufacturing of this product. We hereby certify that the above results have been verified and conform to the above mentioned specifications. Material is Mercury free, without radioactivity.

Aucune réparation exécutée par soudure durant la fabrication de ce produit. Par la présente nous attestons que les résultats ci-haut mentionnés ont été vérifiés et sont conformes aux spécifications. Pas de contact au Mercure, sans radioactivité.

Keith BALL - Branch Manager

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC. J7R 5A8

Tél. 450-475-1884

Télécopieur / Fax administration: 450-491-5492

Télécopieur / Fax production: 450-491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329190	1

CLIENT / customer 236

P.J. MACHINAGE

1381 ROUTE LA CITÉ DES JEUNES

ST-LAZARRE QC J7T 2B8

LIVRÉ À / shipped to.

P.J. MACHINAGE

1381 ROUTE LA CITÉ DES JEUNES

ST-LAZARRE QC J7T 2B8

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
135074	N/A	4140		
SPECIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPECIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	38 - 40 HRC	6	40 - 40 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
6	1,5	6778-B / PULLER 1 BOITE DE CARTON EPS		

19/1/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2018-07-19

METCOR INC.

500 BOUL. ARTHUR-SAINT-ETIENNE, ST-EUSTACHE, QC, J7R 2A8

Tél : 450-473-1824

Télécopieur / Fax administration: 450-491-5492

Télécopieur / Fax production: 450-491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329189	1

CLIENT / customer: 236

PJ MACHINAGE

1381 ROUTE LA CITÉ DES JEUNES

ST-LAZARRE

QC J7T 2B8

LIVRÉ À / shipped to:

PJ MACHINAGE

1381 ROUTE LA CITÉ DES JEUNES

ST-LAZARRE

QC J7T 2B8

COMMANDE DU CLIENT customer po	CLASSIFICATION PIÈCE part classification	MATÉRIEL material	MAÎTRE D'ŒUVRE prime contractor	PROGRAM
135074	N/A	4140		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SEL HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results

HARDNESS 32 - 36 HRC 6 35 - 38 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
6	1.95	6778-C / PULLER 1 SAC DE PAPIER

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2018-07-19

METCOR INC.

500 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tel : 450-475-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450-491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329187	1

CLIENT / customer 236

P.J. MACHINAGE

1381 ROUTE LA CITÉ DES JEUNES

ST-LAZARRE

QC J7T 2B8

LIVRÉ À / shipped to:

P.J. MACHINAGE

1381 ROUTE LA CITÉ DES JEUNES

ST-LAZARRE

QC J7T 2B8

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
135074	N/A	Q1		
<u>SPÉCIFICATIONS DU PROCÉDÉ</u> processing specifications				
SEL HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results				
HARDNESS		32 - 36 HRC	6	34 - 36 HRC
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
6	0,35	8779-D-E-F / ADAPTOR 1 SAC DE PAPIER		

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2018-07-19

Pierre Piché
Chief Inspector





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040560**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040560

PO Date: 7/20/18

Due Date: 7/25/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: ** rush PO, need back asap**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178629-A	RBW6705G00632-3G-1	Yoke -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; -Certificate of Conformity is required	Firmed	-	7/25/18	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	178370	RB6889891	Rotor Splined Compressor Holder -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	7/25/18	2 pcs	0 pcs	2 pcs	\$6.00/pcs	\$12.00
3	178232	RB6891195-1	Locator -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	7/25/18	6 pcs	0 pcs	6 pcs	\$6.00/pcs	\$36.00
4	178235	RB6891195-2	Spline -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	7/25/18	6 pcs	0 pcs	6 pcs	\$6.00/pcs	\$36.00

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	178377	RB23008673-1	Spline -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	7/25/18	2 pcs	0 pcs	2 pcs	\$6.00/pcs	\$12.00
6	178378	RB23008673-2	Spline -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	7/25/18	2 pcs	0 pcs	2 pcs	\$6.00/pcs	\$12.00
7	178379	RB23008673-3	Spline -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	7/25/18	2 pcs	0 pcs	2 pcs	\$6.00/pcs	\$12.00
Grand Total:											\$240.00

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Order Notes**Procurement Quality Clauses**

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/23/18 9:51 AM dart.tsimiklis.chrisoula

CE



Certificat de Conformité / Certificate of Compliance

(011245-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

011245-1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
25-Jul-2018		Aman		040560				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6705G00632-3G-1 Rev.	RBW6705G00632-3G-1 01 -ANO-CLEAR [ANODIZE CLEAR]	ANODIZE CH	6	6	0	0	0
2	RB6889891P Rev.	RB6889891P 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	2	2	0	0	0
3	RB6891195-1P Rev.	RB6891195-1P 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	6	6	0	0	0
4	RB6891195-2P Rev.	RB6891195-2P 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	6	6	0	0	0
5	RB23008673-1P Rev.	RB23008673-1P 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	2	2	0	0	0
6	RB23008673-2P Rev.	RB23008673-2P 01 -OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	2	2	0	0	0
7	RB23008673-3P Rev.	RB23008673-3P 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	2	2	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.